

Need Time 1st

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:21:08 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 32606	
Estimate Number : 12840	
P.O. Number : <u>NIA</u>	Part Number : D35421
This Issue : 5/25/2007 S.O. No. : <u>NIA</u>	Drawing Number : D3542 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32129	Material : <u>NIA</u>
Written By : _____	Due Date : 6/6/2007 Qty: 20 Um: Each
Checked & Approved By : <u>JA 07.05.28</u>	
Comment : Est Rev: A New Issue 07-04-23 JLM	
Est Rev: B updated powder coat per NCR 07.05.16 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"
-----	--------------------	-----------------------



Comment: Qty.: 0.3500 f(s)/Unit Total : 6.9993 f(s)

6061-T6 Bar 3" x 1.5"

BATCH: M16530J.F. 07/05/30

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A

2-Deburr per dwg D3443

J.L. 07/05/31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 07/05/31

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

BE 07.06.01

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/06/04 (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:21:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32606

Part Number: D35421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 10/601



Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

FZ

07/06/04 (20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/06/04

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *37243*

07/06/05 (21)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



u 07-06-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

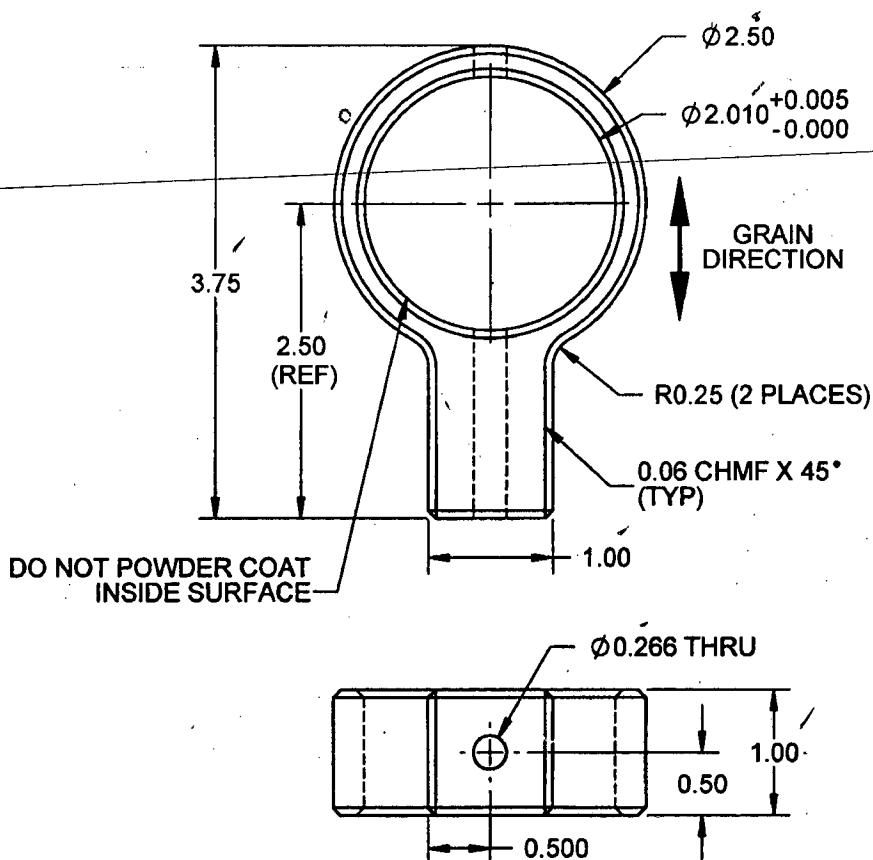
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



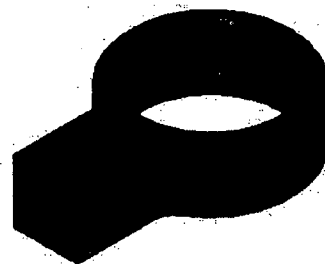
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27		TITLE BRACKET	SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

RELEASED
07.04.02



D3542-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32606



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	32606
Description: bracket		Part Number:	D3542-1
Inspection Dwg: N3542 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	J.L.	Audited by:	J.P.	Prototype Approval:	
Date:	07/05/31	Date:	07/05/31	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	